

AI -3125 058W

Work Order ID 74874

74874

Page 1

October 13, 2011 10:37:34 AM

Item ID: D3681-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spacer
 Start Date: 10/13/11 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 10/27/11 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3681	Rev A								

100 Hardinge CNC LATHE SMALL 0.00
100
 Hardinge Memo 0.00
 Hardinge CNC Lathe Small 1-TURN AS PER FOLIO FA711& DWG D3681
 FOLIO REV: 11
 DWG REV: 1
 2-DEBURR AS REQUIRED

40 0 SL 11/10/23

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

40 0 SL 11/10/23

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

RS 11.10.23

40 1 _____

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WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125		0.00							
125						40	0	BEU/11/09	
Skidtubes	Memo	0.00							
Skidtubes	1- clean crossbolt spacer with ultra brighth aluminum cleaner before storing.								
130	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
130						40	0	BEU/11/09	
Packaging	Memo	0.00							
Packaging	***STOCK IN SKIDTUBE CELL***								
140	QC21- Final Inspection - Work Order Release	0.00							
140								11/11/14	
QC	Memo	0.00							
Quality Control									

11-11-11
40

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WORK ORDER CHANGES

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DATE	STEP						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

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Picklist Print

October 13, 2011 10:37:39 AM

Page 1

Work Order ID: 74874

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Parent Item: D3681-1

D3681-1

Parent Item Name: Spacer

Start Date: 10/13/11

Required Date: 10/27/11

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev A new issue 07-10-30 DD verified by:EC
IPP Rev:B Ecn 1056 Rev A dwg DD IPP Rev:C add
seq 125 DD 10.05.03 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6T0.3125W.05
8

Purchased

No

100

f

89.1230

0.34

14.31579

M6061T6T0 3125W 058

ALUM TUBE .3125 x .058w

**

14.000'

11/10/23

Location

Loc Qty

Loc Code

MAT013

89.123

116793

1.667

116939

23.972

117400

28.9

118438

34.584

12'

2'

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Dart Aerospace Ltd

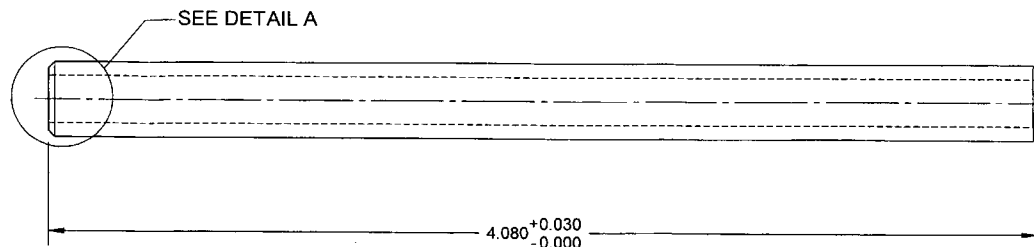
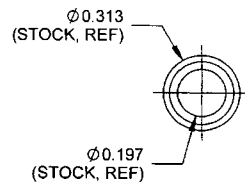
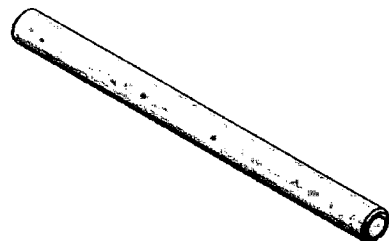
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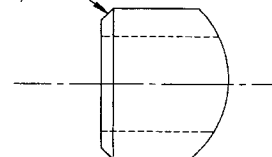


D3681-1 SPACER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 34874 M.L.J
11/10/14

0.025 X 45°
CHAMFER
(TYP)



DETAIL A
(SCALE 4 : 1)

RELEASED
07-11-08

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

A NEW ISSUE		DC	07.11.08
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	MD	DRAWING NO.	REV. A
MFG. APPR.	MD	D3681	SHEET 1 OF 1
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	SPACER	2:1
DATE	07.11.08	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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